



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBEA62309
Job Sheet 179183



Part No: RBEA62309

Job Qty: 1 ea

Part Name: AS350/355 Field Maintenance



Part Weight: 0 lbs

Status: ~~Scheduled~~ *PLANNING*

Priority: Medium

Job Created: 6/14/18

Job Tracking No:

Due Date: 8/21/18

Created By: Logan David

Type: Stock

Description:

Note: RBEA62309 rev.12 IPP REV:A 17.12.13 NEW ISSUE DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Start up Operation	1 Ea	8/21/18	8/21/18	0.00	0.00	Start Up Small Fab-4		<i>7/20</i>
105	Small Fab	1 pcs	8/21/18	8/21/18	0.00	1.00	Small Fab-9		<i>ALL</i>
120	QC	1 pcs	8/21/18	8/21/18	0.00	0.00	QC5		<i>SP</i>
130	Packaging	1 pcs	8/21/18	8/21/18	0.00	0.00	Packaging3-2		<i>SB</i>
140	QC21-FG	1 Ea	8/21/18	8/21/18	0.00	0.00	QC21		<i>DAS</i>

Part Op 105 - 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Pelican case
Descriptions: APP-1700-E 3-Deburr holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Install placard to wheel housing as per DWG 6-Glue foam to case and pack case 7- See note 1 for hoses

SEP 27 2018



Container No: S111034



Part: RBEA62309

Job No: 179183

Serial No/Batch: S111034

Revision: 12

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
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Date: 09/18/18

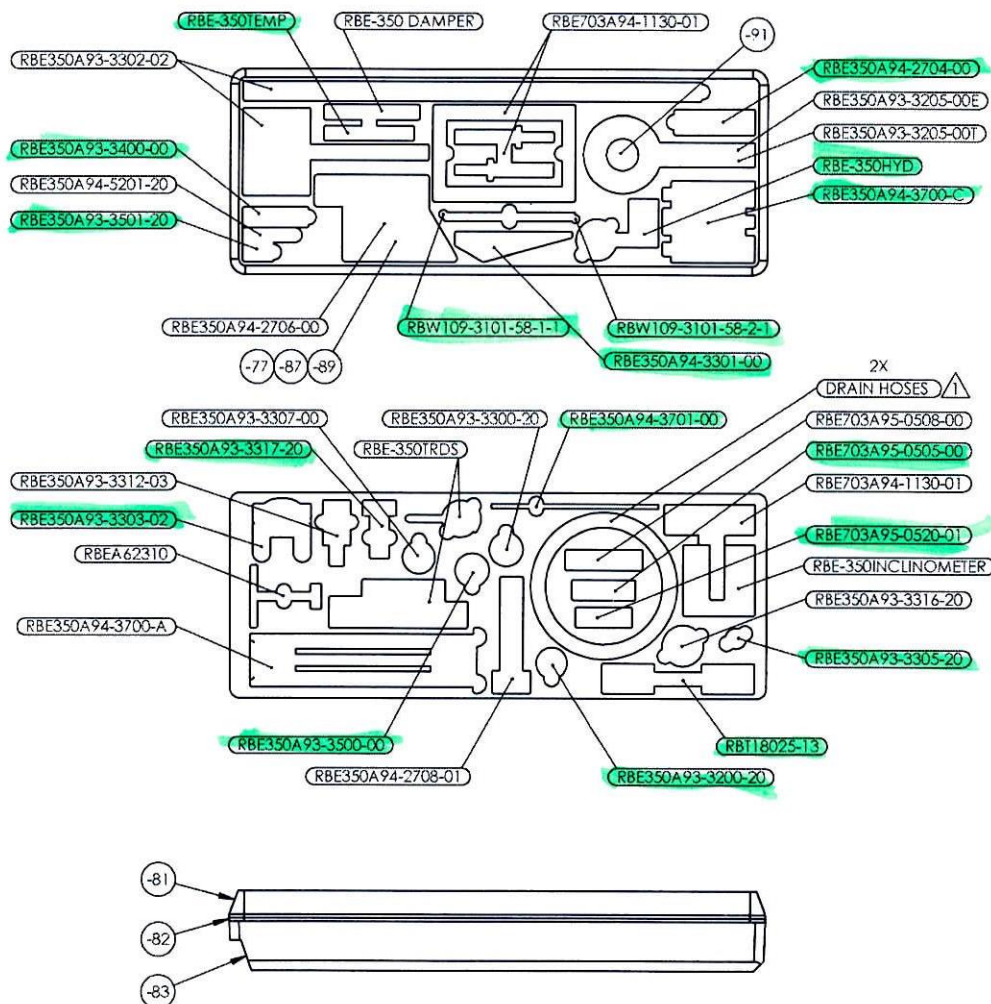
Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RB41011	Dart Tooling Placard, Aluminum	1 Ea (1 ea)	100-Start up Operation	5021040
3896T31	Ferule 1/16 X 3/8" - Aluminum	2 Ea (2 ea)	105-Small Fab	5093315
5274T761	Polypropylene Vial for Flange Wrench Bolts	1 Ea (1 ea)	105-Small Fab	5083897
7189K31	Cable Ties Black	9 Ea (9 ea)	105-Small Fab	5038430
86625K31	Grommet Size 00	1 Ea (1 ea)	105-Small Fab	5038427
9052000	10" Mini Bungee Cord	4 Ea (4 ea)	105-Small Fab	5094610
97524A032	Sealing Blind Rivet	4 Ea (4 ea)	105-Small Fab	5038428
97526A421	Rivet	4 Ea (4 ea)	105-Small Fab	5092381
APP-1700-E	Hard Case	1 Ea (1 ea)	105-Small Fab	5041609
CL-194-TERM-2	Eyelet	1 Ea (1 ea)	105-Small Fab	5093863
CL-2-C	Lanyard Wire	1.1600 ft (1.16 ea)	105-Small Fab	5055799
NAS1756-12	Remove Before Flight	1 Ea (1 ea)	105-Small Fab	3107750
RBE-350DAMPER	Damper Spanner Wrench	1 Ea (1 ea)	105-Small Fab	5098208
RBE-350HYD	Hydraulic Accumulator Fitting Gauge	1 Ea (1 ea)	105-Small Fab	509681
RBE-350INCLINOMETER	Inclinometer	1 Ea (1 ea)	105-Small Fab	5113045
RBE-350TDRS	Tail Rotor Driveshaft Bearing Run-Out Gauge	1 Ea (1 ea)	105-Small Fab	5098175
RBE-350TEMP	Temperature Probe	1 Ea (1 ea)	105-Small Fab	509419
RBE350A93-3200-20	Main Gear Box/Rotor Brake Retaining Nut Wrench	1 Ea (1 ea)	105-Small Fab	5096004
RBE350A93-3205-00E	Engine G/B Input Flange Holding Wrench	1 Ea (1 ea)	105-Small Fab	5096015
RBE350A93-3205-00T	Tail Rotor Gear Box Input Flange Holding Wrench	1 Ea (1 ea)	105-Small Fab	5111734
RBE350A93-3300-20	Tail Rotor Hub Socket	1 Ea (1 ea)	105-Small Fab	5114048
RBE350A93-3302-02	Tail Rotor Hub Lock Wrench	1 Ea (1 ea)	105-Small Fab	5089426
RBE350A93-3303-02	Tail Rotor Head Body Extractor Tool	1 Ea (1 ea)	105-Small Fab	5098735
RBE350A93-3305-20-1	Tail Gearbox Wrench	1 Ea (1 ea)	105-Small Fab	5107555
RBE350A93-3307-00	Tail Gearbox Seal Extractor	1 Ea (1 ea)	105-Small Fab	5101575
RBE350A93-3312-03	Tail Rotor Hub Bushing Replacement Tool	1 Ea (1 ea)	105-Small Fab	5098682
RBE350A93-3316-20-1	Rotating Star Replacement Wrench	1 Ea (1 ea)	105-Small Fab	5108306
RBE350A93-3317-20	Tail Rotor Hub Insert Tool	1 Ea (1 ea)	105-Small Fab	5045019
RBE350A93-3400-00	Drive Shaft Thimble	1 Ea (1 ea)	105-Small Fab	5113008
RBE350A93-3500-00	Bearing Extractor	1 Ea (1 ea)	105-Small Fab	5113344
RBE350A93-3501-20	Extraction Tool, Hydraulic Pump Pulley Bearing	1 Ea (1 ea)	105-Small Fab	5077419
RBE350A94-2704-00	Pedals Locking Tool	1 Ea (1 ea)	105-Small Fab	5109215
RBE350A94-2706-00	Rigging Pin Set	1 Ea (1 ea)	105-Small Fab	5101757
RBE350A94-2708-01	Tail Rotor Blade Locking Tool	1 Ea (1 ea)	105-Small Fab	3111733
RBE350A94-3301-00	T/R Accelerator Support	1 Ea (1 ea)	105-Small Fab	3113181
RBE350A94-3700-A	Swashplate Immobilizing Tools Long Brace & Parts	1 Ea (1 ea)	105-Small Fab	5103441
RBE350A94-3700-C	Swashplate Immobilizing Tool Adjustable Brace	1 Ea (1 ea)	105-Small Fab	3111831
RBE350A94-3701-00	Main Rotor Rigging Tool	1 Ea (1 ea)	105-Small Fab	5099913
RBE350A94-5201-20	Cartridge, Dummy, Fuel	1 Ea (1 ea)	105-Small Fab	5088656
RBE703A94-1130-01	Main Rotor Blade Trim Tab Tools Assembly	1 Ea (1 ea)	105-Small Fab	5092344
RBE703A95-0505-00	Hose, Main Gear Box Tail Gear Box Draining	1 Ea (1 ea)	105-Small Fab	5092359
RBE703A95-0508-00	Main Rotor Gear Box Drain Tube	1 Ea (1 ea)	105-Small Fab	5092374
RBE703A95-0520-01	Engine And Hydraulic Drain Tube	1 Ea (1 ea)	105-Small Fab	5113281
RBE703A95-0520-01-11	Tube	1 (1 ea)	105-Small Fab	5095819
RBE703A95-0520-01-13	Cap	1 (1 ea)	105-Small Fab	5095477
RBE703A95-0520-01-15	Foam	1 (1 ea)	105-Small Fab	5095264
RBEA62309-65	Laminated Location Card	1 Ea (1 ea)	105-Small Fab	
RBEA62309-81	Top Shelf Cushion	1 Ea (1 ea)	105-Small Fab	
RBEA62309-82	Top Cushion Stiffener	1 Ea (1 ea)	105-Small Fab	
RBEA62309-83	Bottom Shelf Cushion	1 Ea (1 ea)	105-Small Fab	
RBEA62310	AS350/355 Engine Strut	1 Ea (1 ea)	105-Small Fab	
RBT18025-13	Linear Scale (50 lbs)	1 Ea (1 ea)	105-Small Fab	
RBW109-3101-58-1-1	Hammer, Steel	1 Ea (1 ea)	105-Small Fab	
RBW109-3101-58-2-1	Hammer, Aluminum	1 Ea (1 ea)	105-Small Fab	

missing Part but have to be
out for october 12

005684

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REVISIONS				
REV	ECN	DESCRIPTION	DATE	INITIAL
1		-#1 REARRANGED TOP SHELF TOOLS. -#3 RECONFIGURED BOTTOM SHELF TOOL ARRANGEMENT TO BETTER FIT RED BARN TOOLS. -#5 RECONFIGURED TOP AND BOTTOM SHELF TOOL ARRANGEMENT TO BETTER FIT RED BARN TOOLS. ADDED LAMINATED LOCATOR CARD AND LATCHED COMPONENTS.	9/23/2009	WP
2		REDRAWN TO USE HELF-PRODUCTS TOOLS AND ALLOW FOR 3 DRAIN HOSES	1/26/2010	WP
2A		ADDED NEW RED BARN PHOTOS	2/11/2010	RJC
3		-#1 REARRANGED TOP SHELF TOOLS. -#3 REARRANGED BOTTOM SHELF TOOL CUSHION TO ACCOMMODATE NEW DIGITAL TORQUE DO LEVEL. ADDED SECTION A-A TO CLAW CUT OUT FOR RBEA94-3700-20. CHD CUTOUT DEPTH FOR RBEA94-3700-A. RBEA94-5201-20 & RBEA93-3501-20. -#5 REARRANGED TOP AND BOTTOM SHELF CUSHIONS TO ACCOMMODATE NEW DIGITAL TORQUE DO LEVEL. CHD CARD INFORMATION FOR L.A.S.	2/18/2010	RJC
4		-#3 REARRANGED TOOL CUTOUPS. ADDED CUT OUT FOR RBEA62310. -#5 UPDATED CARD	3/9/2010	WP
4A		-#9 & -#1 CHD QTY FROM 1 TO 1 SET. UPDATED LAYOUT PHOTOS	3/24/2010	RJC
4B		-#7 & -#9 ADDED ONE TO EACH QTY	7/21/2010	WP
4C		-#91 ADDED CONTAINER FOR RBEA93-3205-00-1 & RBEA93-3205-00-20 NUTS & BOLTS.	10/27/2010	WP
5		-#1 DELETED CUTOUT NOTCHES FOR RBE-RDGS-15.	6/20/2011	RJC
6		CORRECTED DRAIN HOSE 1/4" FROM RBEA93-1002-01 TO RBEA93-0202-01. -#3 CHD FOAM CUTOUTS FOR RBEA93-3500-00. RBEA93-3300-20. RBEA93-3200-20 & RBEA93-3317-20 FOR BETTER FIT. -#5 UPDATED CARD.	2/27/2012	RJC
7		-#3 CHD TOOL LAYOUT. ADDED NEW DESIGN FOR DRAIN HOSES & CUTOUPS FOR INDIVIDUAL QUILLS. CHD CUTOUT FOR RBEA94-3700-A FOR BETTER FIT. -#5 UPDATED CARD.	1/9/2013	RJC
7A		-#5 CORRECTED ITEM QTY FROM RBEA93-3305-02 TO RBEA93-3305-20. CHD QTY FROM 1 TO 1. ADDED 1 DRAIN HOSE QTY. 2. CHD LOCATIONS D1 & D2 TO D AND X1, X2, & A3 TO X.	3/11/2013	RJC
8		-#1 CHD DIM WAS 75.5 & 4.44. -#3 CHD CUTOUT LOCATION FOR RBE350A94-3700-A. -#5 CORRECTED 1/4" & TOOL DESCRIPTION TO MATCH CURRENT DRAWING.	10/24/2013	OPS
9		-#1 CHD CUTOUT FOR RBE-350HYD (NEW GAUGE). CHD CUTOUT FOR RBE350A94-3700-C TO FIT BETTER. -#3 CHD CUTOUT FOR RBE350A94-3700-A TO SEC. RE TOOLS BETTER.	3/25/2014	RJC
10	15-0038	UPDATED TO NEW DRAFTING STANDARDS. -#3 CHD FOAM TO ACCOMMODATE SNAP-ON INCLINOMETER. -#5 CHD CARD TO CLAW R597-1001. LATCH WITH SNAP-ON INCLINOMETER.	2/11/2015	DPS
11	16-0149	-#1 ADDED DETAIL SHEET REPLACED RBE-RDGS-15 WITH RB18025-13 AND MOVED TO -#3. ADDED RBW109-3101-58-1 & RBW109-3101-58-2. CHD MATERIAL WAS 120 BLACK EETHAFOAM 220. BLACK. -#2 ADDED DRAWING. -#3 ADDED DETAIL SHEET. CHD TOOL LAYOUT. CHD DIM WAS 4X 6.64 IS 3X 6.64 & 45. DELETED DIM 73 (D2). HP 120. 1.38 (D2) & 9.13 (44) UPPER. AND ADDED DIM 74. 1.48 & 1.25. CHD FOAM WAS 120 BLACK EETHAFOAM 220. BLACK. MOVED RBE350A93-3400-00. RBE350A94-5201-20 & RBEA93-3501-20 TO -#1. -#3 RBE-RDGS-15 REPLACED W/ RB18025-13. -#5 REARRANGED TOOLS TOP AND BOTTOM. ADDED RBW109-3101-58-1. RBW109-3101-58-2. RB18025-13. -77, -87, & -89.	9/20/2016	RJC
12	17-0013	-#1 CHD DIM WAS 820.8 & 82. -#3 CHD DETAIL ORGANIZATION: REMOVED DIM 3 X 9.86, 3X 1.38, 33.47, 24.34, 17.92, 25.807, 7.13. ADDED DIM 67.75, 30.13, 5.49, 12.77, 9.13, 8.38, 5X 6.50, 2X 6.63, 2X 6.13, 6.50. CHD DIM WAS 10.24 IS 3X 10.24 WAS 29.34 IS 6.34 6.63 WAS 12.33 IS 6.80 WAS 11.56 IS 11.57. -#5 REARRANGED TOOLS TOP AND BOTTOM SHELF. UPDATED ITEM 12 & 13 TOOL NUMBERS.	1/24/2017	SM

NOTE:

7 FT. HOSES MUST COUPLE IN CUTOUT. MIN TRIM ACCEPTABLE.

		AS350-355 FIELD MAINTENANCE KIT	
		RBEA62309	REV 12
DWG NO.		REV	
MATL		UNLESS OTHERWISE SPECIFIED	
REAR		DIMENSIONS ARE IN INCHES	
FRONT		FRACTIONS ± 1/8	
SPEC		ANGLES ± 1°	
1. BREAK ALL SHARP EDGES		± .015 ± .015 OR .0156	
2. DIMENSIONAL LIMITS APPLY		± .015 ± .015 OR .0156	
3. INTERPRET DIM AND TOL PER		ASME Y14.5M-2009	
QA APPR: LINDSAY		USED ON MODEL	
APPROVED: GILBERT		AS350/355	
SCALE 1:8		DATE 9/20/2016	
SHEET 1 OF 8			